

Date: Tuesday, 06/05/2008 3:49:33 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	EC120 WEARPLATE KIT
Job Number :	39080		
Estimate Number :	11513		
P.O. Number :		Part Number :	D120639011
This Issue :	06/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	/ /	Project Number :	N/A
Previous Run :	37720	Drawing Revision :	N/A
	Type :	Material :	
	PURCHASED PARTS	Due Date :	11/05/2008
Written By :		Qty:	2 Um: Each
Checked & Approved By :	JLD 08.5.08		
Comment :	Est. D 02.09.13 Re-format, Added MS27130-S30 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels per PPP D120-639-011 CHG 002

JLD
 08/05/08 8.5.08

2.0	D2746	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Wearshoe

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2746	Wearplate	35495

AS 08/05/08

3.0	D265631	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Wearplate

Qty	Part Number	Description	Batch
1	D2656-31	Wearplate	15166

AS 08/05/08

4.0	D265613	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Wearplate

Qty	Part Number	Description	Batch
1	D2656-13	Wearplate	35542

AS 08/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC120 WEARPLATE KIT

Job Number: 39080

Part Number: D120639011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Wearpad

Qty Part Number

Description

Batch

5 D2648-3

Wearpad

34591

AS 08/05/08 (X2)

6.0

ALS71032130

Insert



Comment: Qty.: 36.0000 Each(s)/Unit Total : 72.0000 Each(s)

Insert

Qty Part Number

Description

Batch

36

ALS7-1032-130

Insert

M105855

Or AKS7-1032-130

Or ALS4-1032-130

Or AKS4-1032-130

AS 08/05/08 (X2)

7.0

MS27039108

Screw



Comment: Qty.: 40.0000 Each(s)/Unit Total : 80.0000 Each(s)

Screw

Qty Part Number

Description

Batch

40

MS27039-1-08 Screw

M106589

AS 08/05/08 (X2)

8.0

AN960JD10L

Washer



Comment: Qty.: 40.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer

Qty Part Number

Description

Batch

40

AN960JD10L

Washer

M104885

AS 08/05/08 (X2)

9.0

MS27130S30

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Insert

Qty Part Number

Description

Batch

4

MS27130-S30 Insert

or RNS1032-330

M100154

AS 08/05/08 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 3:49:33 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC120 WEARPLATE KIT

Job Number: 39080

Part Number: D120639011

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/05/08 (H)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package and Identify as per PPP D120-639-011

Rev H

08/05/08 (H)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/09 (H)

Job Completion



MF 08-05-08.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE

The following weight and balance information is for the Dart wearplate kits that are being installed. The weight and balance of any wearplates that are being removed from the aircraft is the responsibility of the installer.

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D120-639-011 TUNGSTEN CARBIDE WEARPLATE KIT	3.1 lb 1.4 kg	136.0 in 3.45 m	422 in lb 4.8 m kg	±40.7 in ±1.04 m	±126 in lb ±1.5 m kg
D120-639-013 SURFACITE™ WEARPLATE KIT	4.1 lb 1.8 kg	136.0 in 3.45 m	558 in lb 6.2 m kg	±40.7 in ±1.04 m	±167 in lb ±1.9 m kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D120-639-011	TUNGSTEN CARBIDE WEARPLATE KIT
	X	D120-639-013	SURFACITE™ WEARPLATE KIT
1	1	D2746	WEARPLATE
1	1	D2656-31	WEARPLATE
1	1	D2656-13	WEARPLATE
5		D2648-3	WEARPAD
	5	D2648-7	WEARPAD
40	40	ALS7-1032-130 or AKS7-1032-130 or ALS4-1032-130 or AKS4-1032-130	INSERT
40	40	MS27039-1-08	SCREW
40	40	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39080

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Revision: **A**

Date: 00.12.11